

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024889**Date Inspected:** 18-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 14, 14W

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

DP3183-001-001~006

This QA Inspector observed following work in progress:

BAY 14, 14WEST

This QA Inspector observed ZPMC qualified welding personnel identified as 066734 perform welding by Shielded Metal Arc Welding (SMAW), on Anchor plate I Rib stiffener to Floor beam weld of OBG Segment 14W. Weld joint is identified as SEG3020M-064. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance

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with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067904 perform welding by Shielded Metal Arc Welding (SMAW), on Anchor plate I Rib stiffener to Floor beam weld of OBG Segment 14W. Weld joint is identified as SEG3020R-186. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 068097 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam I Rib stiffener to longitudinal diaphragm weld of OBG Segment 14W. Weld joint is identified as SEG3020M-196. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 069683 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel I stiffener plate to longitudinal diaphragm weld of OBG Segment 14W. Weld joint is identified as SEG3020AB-017. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2212-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
